

Date: Wednesday, 5/23/2007 3:43:15 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Na
Job Number	: 32503		
Estimate Number	: 10400		
P.O. Number	: N/A		Part Number
This Issue	: 5/23/2007	S.O. No.	: N/A
Prsht Rev.	: NC		Drawing Nu
First Issue	: N/A		Project Nu
Previous Run	: 30275		Drawing Re
Written By	:		Material
Checked & Approved By	:		Due Date
Comment	: Est.C 08.04.11		Reformat; Incorporated D2968-1/I-5 KJ/RF

Drawing Name : TOW RING
Part Number : D2968043
Drawing Number : D2968
Project Number : N/A
Drawing Revision : B1
Material : *N/A* *30 8*
Due Date : 6/30/2007 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 32503A STEM  

Comment: Sub-Component STEM
D2968-3 B 32503 A FC

Comment: Sub-Component RING

D2968-5 B 207910 x14 B302150 x 16 Fe

Comment: LARGE FABRICATION RESOURCE 1
Weld D2968-3 & D2968-5 as per Dwg D2968 & QSI 004 using 4130 welding rod Identify as D2968-043

Batch: M102226 - FC 07/06/25 (32)

Comment: VISUAL WELDING INSPECTION
5.0 QC5 INSPECT WORK TO CURRENT STEP 07/06/25 (3)

Comment: INSPECT WORK TO CURRENT STEP

6.0 OUTSIDE SERV.30 OUTSIDE SERVICES-MACH

Comment: Sub-Contracting PURCHASING
Issue P/O: 4039 207/06/25
Description: D2968-043 to heat treat to ultimate tensile strength

Description: D2968-045 to heat treat to ultimate tensile strength.
125ksi as per Dwg D2968
Conformity sheet required

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Drawing Name: TOW RING

Job Number: 32503

Part Number: D2968043

Job Number:



Seq. #:

Machine Or Operation:

Description:

Issue P/O: 4039

Cad Plate per QQ-P-416F Class I Type II
Conformity sheet required

207/07/25

(30)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

EP 07/07/25 (8)

8.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 07/07/26 (8)

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

DO NOT POWDER COAT THREADS

Unpainted

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

5/23/07
Stock unpa

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

Stock unpa

EP 07/07/27 (8)

12.0 QC21

FINAL INSPECTION/W/O RELEASE



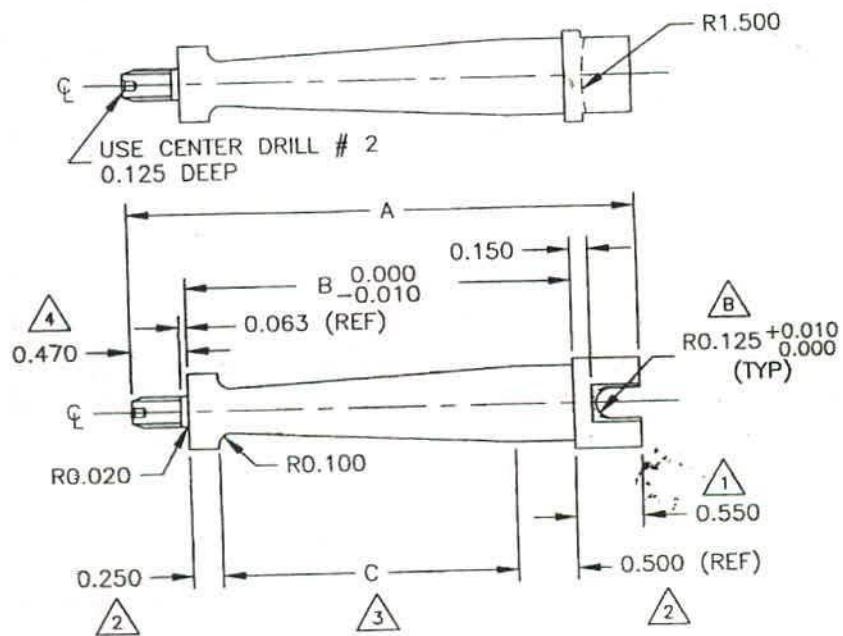
Comment: FINAL INSPECTION/W/O RELEASE

EP 07/07/27

W 07/07/27

Job Completion:





PART NUMBER	A	B	C
D2968-1	5.040	4.020	3.270
D2968-3	4.200	3.180	2.430

D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130

△ Ø.750 O.D.

△ Ø.625 O.D.

△ MACHINE UNIFORM TAPER FROM Ø.363 O.D.
TO Ø.625 O.D.

△ 1/4-28 UNF THREAD WITH 0.063 GRIP
MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
UNLESS OTHERWISE INDICATED

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

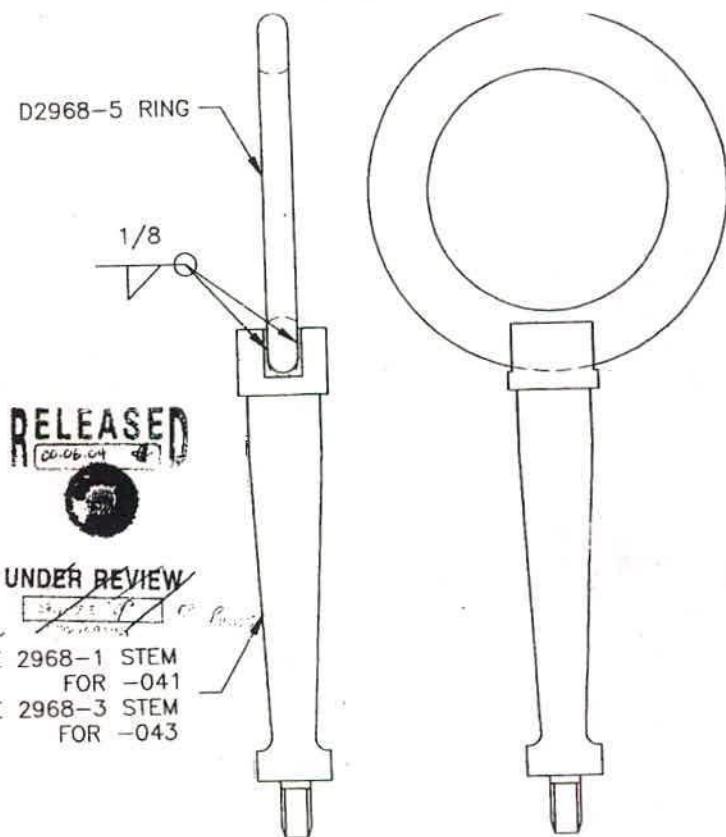
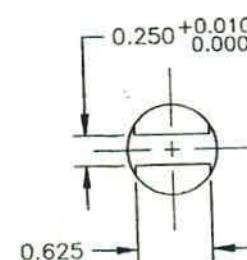
D2968-5 RING:

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

NO. 32503
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
ENGINEERING
CONTROLLED COPY
SHOP COPY
RETURN TO

D2968-5 RING



D2968-041 AND D2968-043 TOW RING:
WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
FINISH: CAD PLATE ENTIRE ASSEMBLY PER
QQ-P-416F CLASS I TYPE II
POWDER COAT WHITE (REF 4.3.5.2) PER DART
QSI 005 4.3 (EXCEPT THREADS)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	DRAWN BY	DART
checked	RF	DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECDED	APPROVED	DRAWING NO.
		D2968
DATE	TITLE	
00.05.31	TOW RING	

REV. B
SHEET 1 OF 1
SCALE
1:1